

WHAT IS CLAIMED IS:

1. A manufacturing system comprising,

a plurality of cell conveyers being supplied with a variety of pallets and products through an input section thereof, said conveyor on which said products are firstly assembled;

a main conveyor whereto said firstly assembled products are conveyed from said cell conveyers in a state that said firstly assembled products are loaded on said pallet, said main conveyor on which said products are finally assembled; and

a return conveyor for returning said pallets to the input section of said cell conveyers after assembly process of said product is completed on said main conveyor;

wherein said pallets are supplied into the input section of said cell conveyers and then returned to said input section of said cell conveyers through said main conveyor and said return conveyor, said variety of products are firstly assembled on said cell conveyers respectively and then conveyed to said main conveyor to be finally assembled, and said variety of products are outputted through an output section of said main conveyor.

2. The manufacturing system as claimed in claim 1 further comprising a plurality of pallet input devices disposed between an output section of said return conveyor and input section of said cell conveyers, said pallet input devices comprising:

a first unit conveyor elevatably installed at said output section of said return conveyor, said first unit conveyor for elevating the outputted pallet from said returning conveyor upwardly;

a second unit conveyor simultaneously elevated with said first unit conveyor, said

second unit conveyer for receiving said pallet elevated by said first unit conveyer therefrom; and

a pallet supply conveyer elevatably installed between a lower portion of said second unit conveyer and a front section of said cell conveyers, said pallet supply conveyer for supplying said pallet conveyed to said second unit conveyer to the input section of said cell conveyers.

3. The manufacturing system as claimed in claim 1 still further comprising a plurality of pallet carriers disposed between the output section of said cell conveyers and input section of said main conveyer, said pallet carriers comprising:.

a third unit conveyer moving in an orthogonal direction with respect to a moving direction of said cell conveyers and elevatably installed at the output section of said cell conveyers, said third unit conveyer for elevating said pallet outputted therefrom; and

a fourth unit conveyer moving in a same direction with said third unit conveyer and elevatably installed at the input section of said main conveyer, said fourth unit conveyer for supplying said pallet to the input section of said main conveyer by receiving and de-elevating said pallet elevated by said third unit conveyer.

4. The manufacturing system as claimed in claim 2, wherein each of said unit conveyers is elevated by an actuator installed at a lower portion thereof.

5. The manufacturing system as claimed in claim 3 further comprising a reversing apparatus installed at a rear section of said pallet carrier which conveys said pallet from one

of said cell conveyers to said main conveyer, said reversing apparatus for arranging said product on said pallet conveyed along said main conveyer by reversing said pallet conveyed from one of said cell conveyers, said reversing apparatus comprising:

a reversing table whereon said pallet is positioned;

- 5 an actuator for elevating said reversing table over said main conveyer; and
 a rotary actuator for reversing said reversing table elevated by said actuator by

180°

6. The manufacturing system as claimed in claim 1, further comprising a pallet
10 returning conveyer installed between said main conveyer and said returning conveyer, said
pallet returning conveyer selectively connected with a pallet output section of said main
conveyer and an input section of said return conveyer by pivoting thereof so as to return
said pallet outputted from said pallet output section of said main conveyer to an input
section of said returning conveyer.

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